

Work Order ID 97779

February-22-13 11:41:53 AM

97779

Page 2

Item ID: D3560-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 2/22/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/27/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

140

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

and 13/02/26

8 0

8 0

13.04.29

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Item ID: D3560-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Weldment
 Start Date: 2/22/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/27/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00				(8)	B-04-30		DAS 09 2-23
Quality Control									
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160									
QC	Memo	0.00				(8)	B-01-30		DAS 09 2-23
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									

8 φ Ae 13.05.02

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Item ID: D3560-042 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Weldment
 Start Date: 2/22/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/27/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				8x			EB3/ps/p
190 *190* Small Fab Small Fab	Small Fab Memo I-Press bushing in D3560 arm per dwg D3562	0.00 0.00				8x			EB3/ps/p
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			EB3/ps/p

IDENTIFY + STOCK

LOCATION: WA003

(X1)

Ac 13.05.06

pl 13-05-06

Picklist Print

February-22-13 11:41:52 AM

Page 1

Work Order ID: 97779

Parent Item: D3560-042

Start Date: 2/22/13

Required Date: 2/27/13

Parent Item Name: Arm Weldment

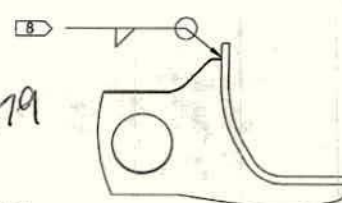
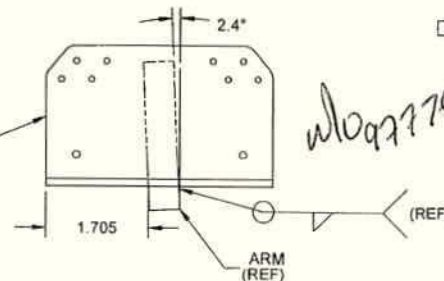
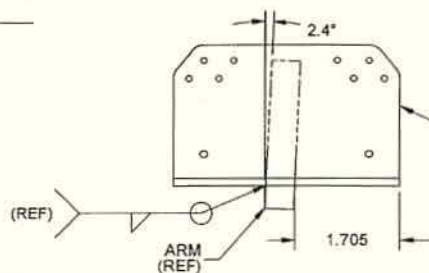
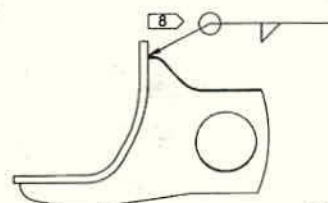
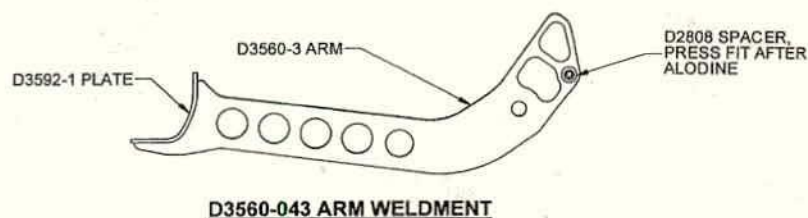
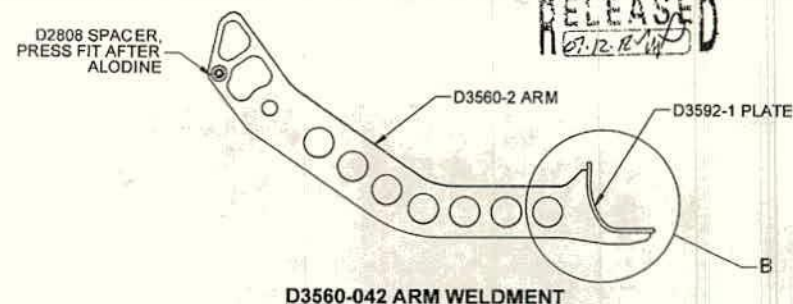
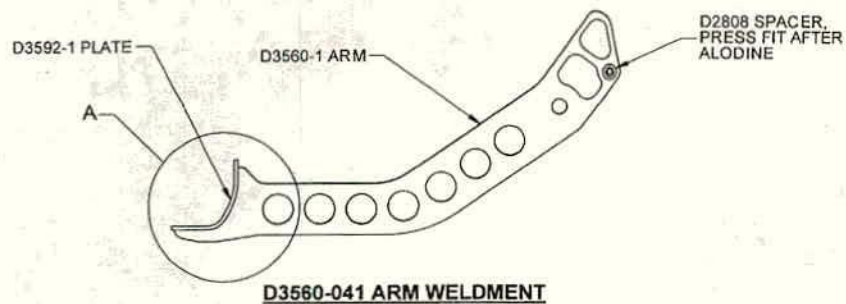
Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808 Bushing		Manufactured	No			100	Each	82.0000	1	4		2/23/05/02	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		82							
				82018		42							
				85479		40							
D3592-1 Plate		Manufactured	No			190	Each	31.0000	1	4		2/13/04/29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA002 397778		2							
				47015		2							
				WA003		29							
				80379		3							
				82022		8							
				82248		18							
M6061T6B0.500X05.000 6061-T6 Bar .500 x 5.00		Purchased	No			140	f	17.3500	1.395	5.8736842			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT001		13.16							
				119346		1.16							
				124681		12							
				MAT004		4.19							
				121040		4.19							

11.08 OK 13/02/22



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

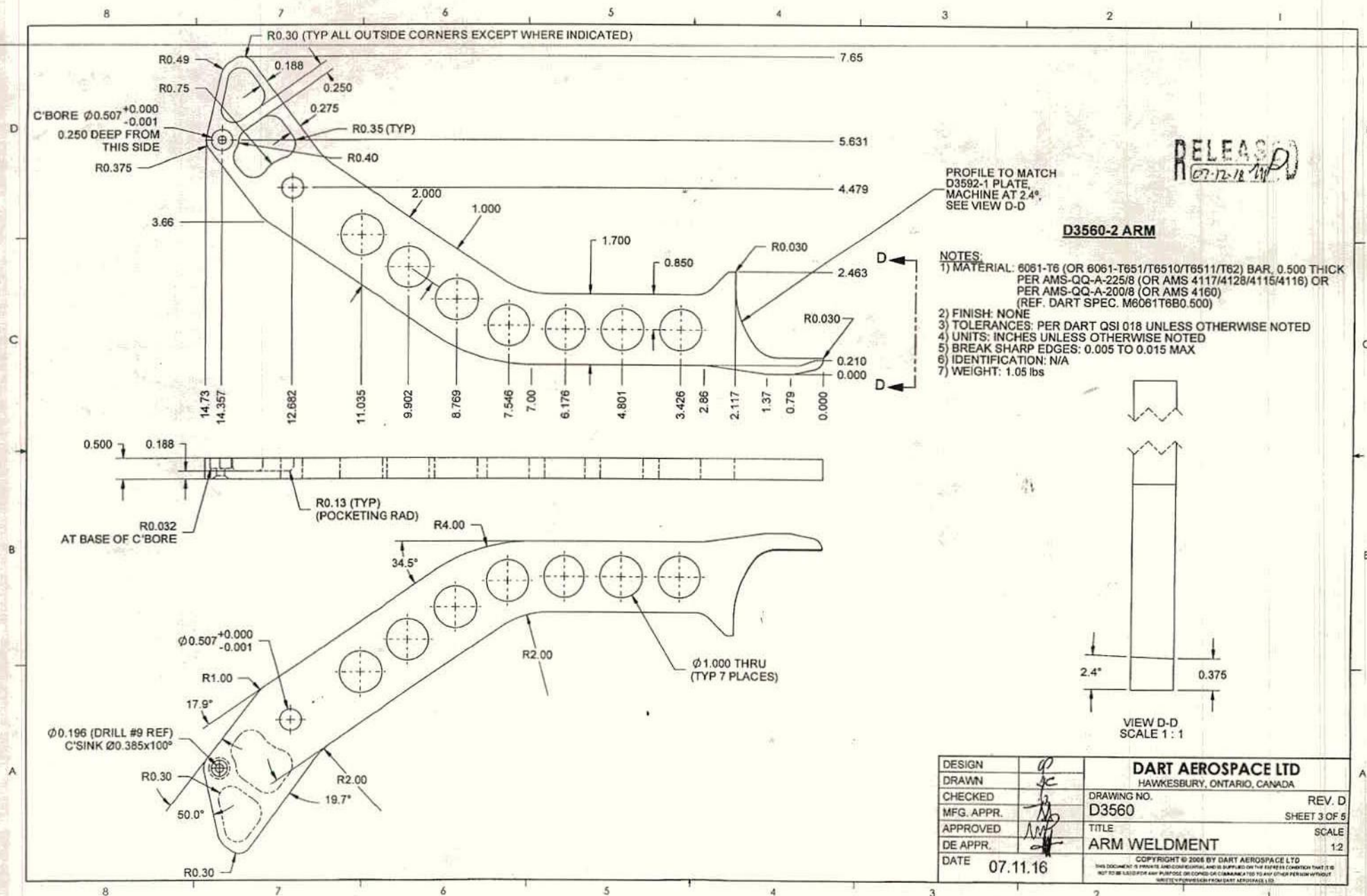
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN	19P		
DRAWN	10C		
CHECKED	19		
MFG. APPR.	19P		
APPROVED	19P		
DE APPR.	19P		
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

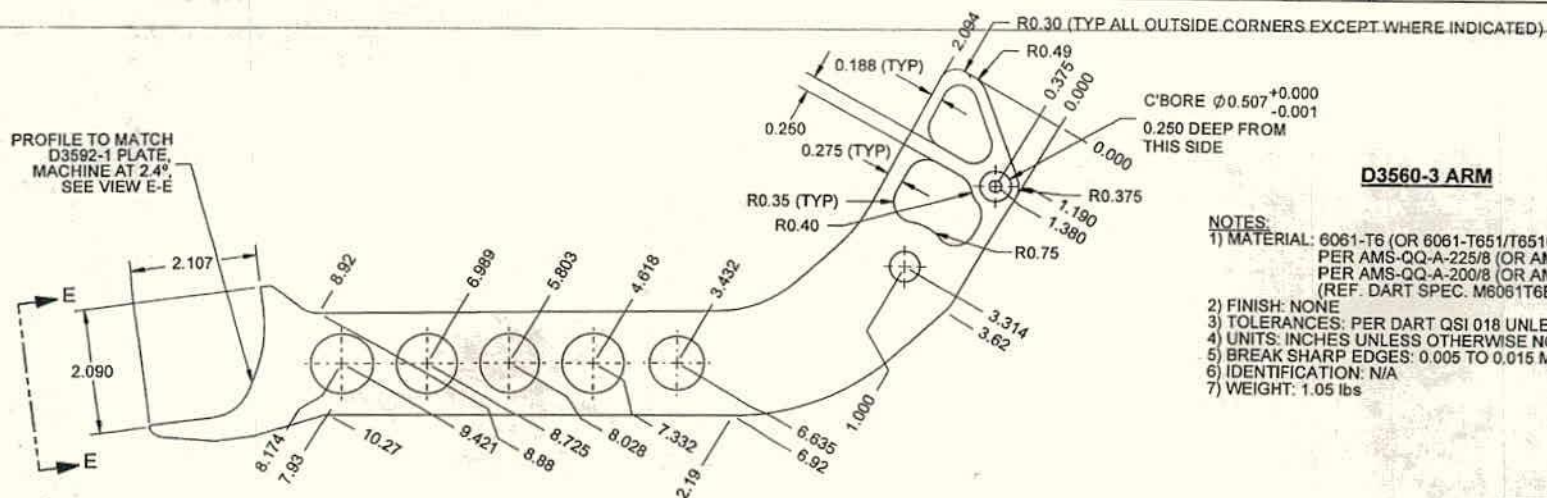
DRAWING NO. **D3560** REV. D
SHEET 1 OF 5
TITLE **ARM WELDMENT** SCALE 1:4

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DESIGN	0	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. I
MFG. APPR.	AM	D3560	SHEET 3 OF 5
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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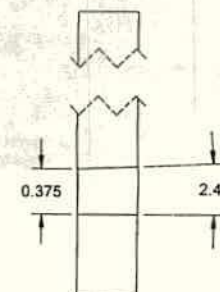
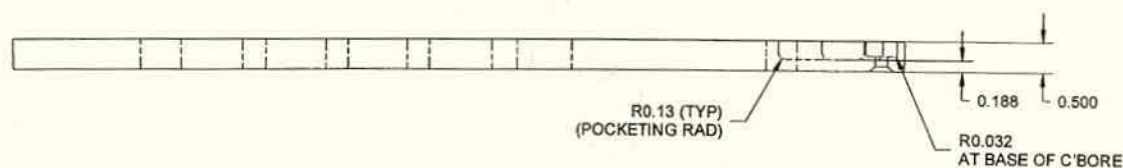
PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E



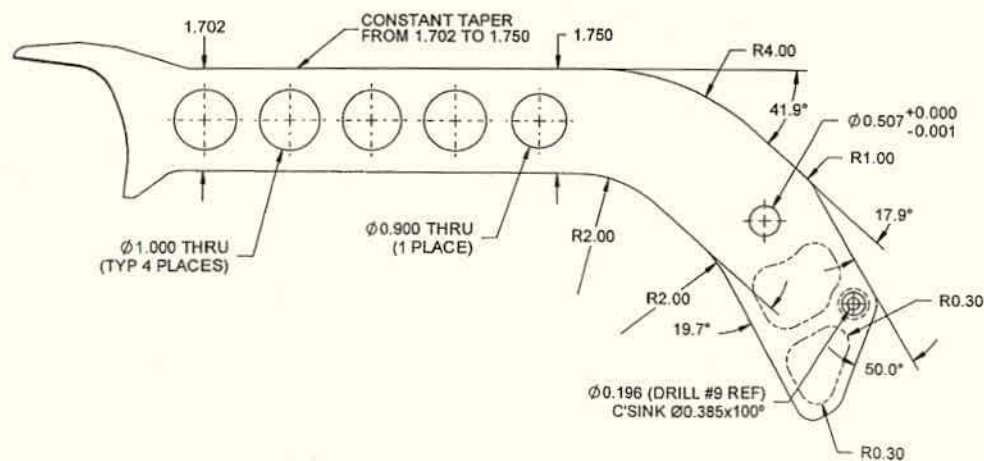
D3560-3 ARM

NOTES:

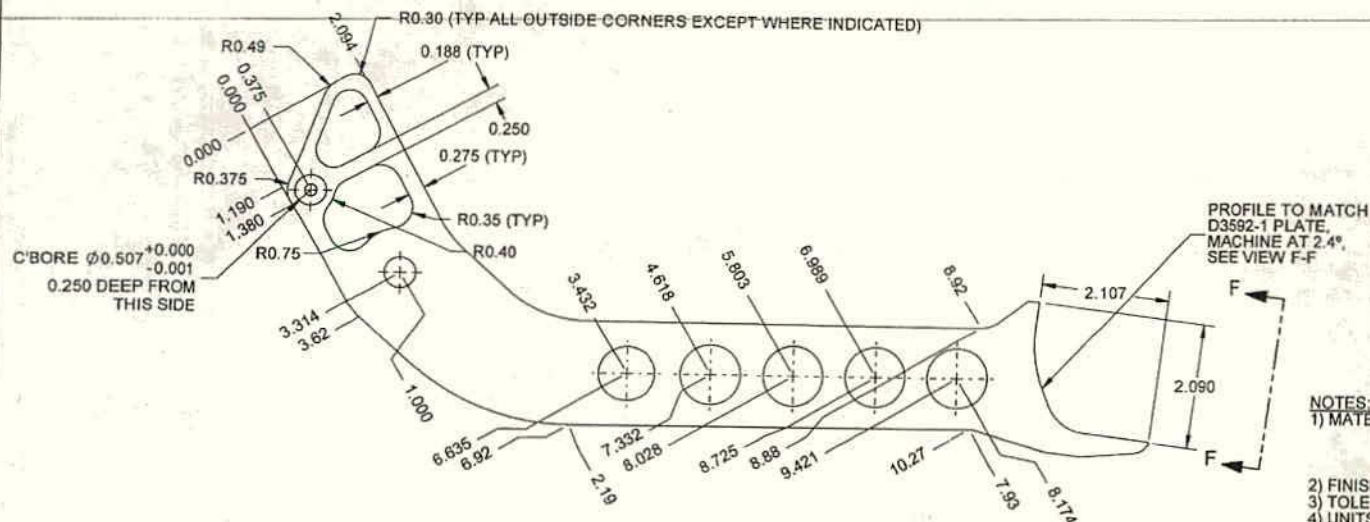
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW E-E
SCALE 1:1



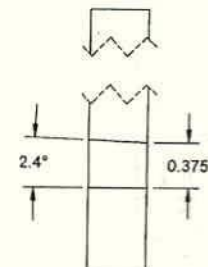
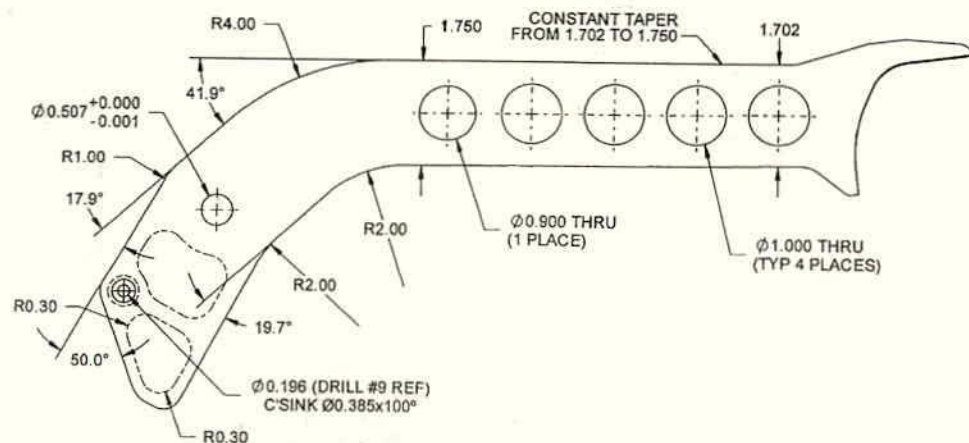
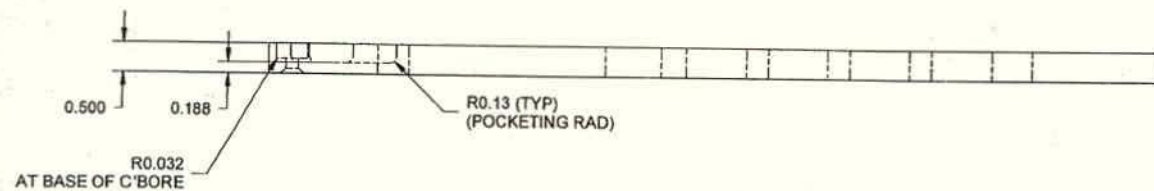
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CHECKED	JA	DRAWING NO.	REV. D
MFG. APPR.	JA	D3560	SHEET 4 OF 5
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PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°
SEE VIEW F-F

D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

DESIGN		DART AEROSPACE LTD	
DRAWN	PC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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